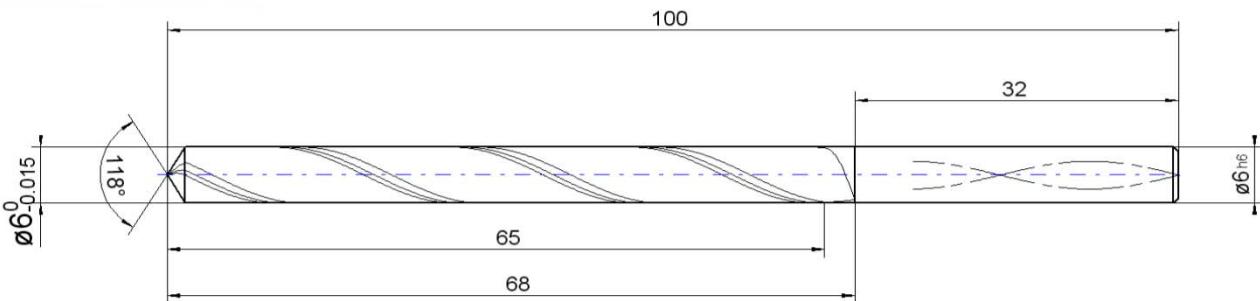


Carbide Drill Ø6 Z2

A05-054



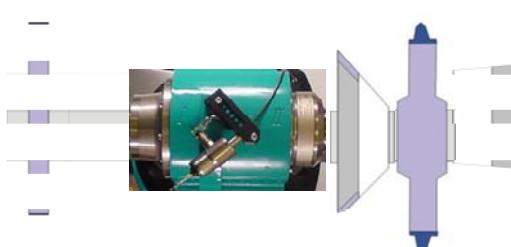
1. Cycletime for Production

Workpiece: Ø6 Ltot 100, LC 65 mm Material CARBIDE						
Operations	Probe	Flute 1	Gashing	O.D.2	End 2	End 1
Feed [mm/Min]	2000	60	80	150	70	100
Power [kW]		3	2	1	1	1
Cutting speed [m/s]		18	20	22	22	22
Used wheels		1	2	3	4	4
Grinding time [s]	12	161	19	83	40	36
Total cycle time	5 Min 51					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	DXF Ø150 D64
2	12V9 Ø125 D64
3	1A1 Ø125 D64
4	11V9 Ø100 D64



3. Machine and Software Requirements

Machines:	5 axes CNC grinders : NORMA CFG	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 310i	Software:	Quinto 5
Accessories:	Steady Rest		
Responsible engineer:	OP, 27.2.14		

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